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**APPLICATION
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TITLE: DIGITAL RELIABILITY MONITOR HAVING
AUTONOMIC REPAIR AND NOTIFICATION CAPABILITY

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DIGITAL RELIABILITY MONITOR HAVING AUTONOMIC REPAIR AND NOTIFICATION CAPABILITY

FIELD OF THE INVENTION

The present invention relates to the field of fault tolerance in integrated circuits; more specifically, it is directed toward a circuit structure and method for repairing
5 integrated circuit elements prior to failure, and a method of designing an integrated circuit with autonomic repair capability.

BACKGROUND OF THE INVENTION

As the frequency performance of integrated circuits continues to increase, the rate
10 of certain failure mechanisms increases in proportion to operating frequency, thereby reducing the time over which an integrated circuit can be expected to reliably perform. Such degradations in reliability caused by technology features needed to improve performance are difficult to compensate for with current integrated circuit design techniques. Therefore, a structure and method for mitigating the probability of early
15 failures due to increased operating frequency is needed.

SUMMARY OF THE INVENTION

A first aspect of the present invention is an integrated circuit, comprising: a pulse generator adapted to generate a pulsed signal; a cycle counter adapted to count cycles of

the pulsed signal; one or more repairable circuit elements; and a repair processor adapted to repair a repairable circuit element when the cycle counter reaches a pre-determined cycle count.

A second aspect of the present invention is a method of preemptively repairing an
5 integrated circuit, comprising: (a) providing a pulse generator adapted to generate a pulsed signal; (b) providing a cycle counter adapted to count cycles of the pulsed signal; (c) providing one or more repairable circuit elements; and (d) providing a repair processor adapted to repair a repairable circuit element when the cycle counter reaches a pre-determined cycle count.

10 A third aspect of the present invention is a method for designing a repairable integrated circuit, comprising: generating an integrated circuit design from a design library of circuit elements; simulating the integrated circuit design and generating a switching report for circuit elements of the integrated circuit design; selecting a circuit element responsive to a pulsed signal of the integrated circuit design based on the
15 switching report; selecting a repairable circuit element from the design library, the repairable circuit element having the same function as the selected circuit element and allowing multiple connection paths; and inserting the selected repairable circuit element, a cycle counter adapted to count cycles of the pulsed signal and repair processor adapted to repair the repairable circuit element when the cycle counter reaches a pre-determined
20 value into the integrated circuit design.

A fourth aspect of the present invention is a computer system comprising a processor, an address/data bus coupled to the processor, and a computer-readable memory unit adapted to be coupled to the processor, the memory unit containing instructions that when executed by the processor implement a method for a method for designing a repairable integrated circuit, the method comprising the computer implemented steps of:

5 generating an integrated circuit design from a design library of circuit elements; simulating the integrated circuit design and generating a switching report for circuit elements of the integrated circuit design; selecting a circuit element responsive to a pulsed signal of the integrated circuit design based on the switching report; selecting a

10 repairable circuit element from the design library, the repairable circuit element having the same function as the selected circuit element and allowing multiple connection paths; and inserting the selected repairable circuit element, a cycle counter adapted to count cycles of the pulsed signal and repair processor adapted to repair the repairable circuit element when the cycle counter reaches a pre-determined value into the integrated circuit

15 design.

BRIEF DESCRIPTION OF DRAWINGS

The features of the invention are set forth in the appended claims. The invention

20 itself, however, will be best understood by reference to the following detailed description

of an illustrative embodiment when read in conjunction with the accompanying drawings,
wherein:

FIG. 1 is a schematic block diagram of an integrated circuit according to a first
embodiment of the present invention;

5 FIG. 2 is a schematic block diagram of an integrated circuit according to a second
embodiment of the present invention;

FIG. 3 is a diagram illustrating a first circuit implementation of the present
invention;

FIG. 4 is a diagram illustrating a second circuit implementation of the present
10 invention;

FIG. 5 is a diagram illustrating a third circuit implementation of the present
invention;

FIG. 6 is a schematic block diagram of an integrated circuit according to a third
embodiment of the present invention

15 FIG. 7 is a diagram illustrating a fourth circuit implementation of the present
invention;

FIG. 8 is a schematic diagram of a first exemplary circuit utilizing the present
invention;

FIG. 9 is a schematic diagram of a second exemplary circuit utilizing the present
20 invention;

FIG. 10 is a flowchart illustrating a method of designing an integrated circuit according to the present invention; and

FIG. 11 is a schematic block diagram of a general-purpose computer for practicing the present invention.

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DETAILED DESCRIPTION OF THE INVENTION

For the purposes of the present invention, the terms integrated circuit and integrated circuit chip are interchangeable. A repair is defined as the replacement of a circuit element by a circuit element of the same function. A circuit element is defined as
10 digital or analog circuit, a memory circuit, a latch, a group of logic gates, a logic gate or a device (such a transistor, a diode, a resistor, a capacitor, an inductor or a wire). A repair is further defined to include adjustment of a circuit element such that an attribute of an output of that circuit element is changed in magnitude.

A signal cycle is defined as the sum of: the time the signal is maintained at a first
15 state, the time required for the signal to transition to a second state from the first state, the time the signal is maintained at the second state and the time required for the signal to transition from the second state back to the first state. Cycles may thus be counted by counting every other transition of the signal state. A clock signal is a special type of pulsed signal. For a clock signal, the cycle is uniformly periodic. Although the present
20 invention is described using clock cycles, it is equally applicable to other types of cyclic or pulsed signals, such as encoded, multiplexed or modulated digital signals.

For a given process technology statistical analysis shows that an integrated circuit element may be expected to reliably transition a finite number of times prior to failure. A number of environmental factors and electrical characteristics of the integrated circuit contribute to this statistical analysis. For example, hot electron injection can stress the gate dielectric of the transistor each time the transistor is switched. The cumulative effect of many switching cycles may ultimately lead to transistor failure. Another example is a failure caused by electro-migration in the interconnect structure of an integrated circuit. At higher frequencies, more current is carried per unit time than at lower frequencies, causing the local current densities of chip interconnect structures to increase dramatically. While most prevalent in metallic structures, this phenomenon may also occur in heavily doped semiconductors. Current crowding in an isolated area may cause voids or stems to form in the circuit material resulting in open or short circuits. The electro-migration process will accelerate with the accompanying increase in temperature. These types of circuit failures and their respective probabilities can be related to system clock cycles.

In a simple example, given a microprocessor lifetime of 27.77 K power on hours (Kpoh) and a latch within the microprocessor operating at 1GHz, the total clock cycles over the useful life of the chip equates to 100E15. It is determined that during each clock cycle the latch degrades at the rate of 1E-15 % per clock cycle at a given V_{DD} power level. With a specification set at 10% margin at 25Kpoh, the reliable life of the latch is 90E15 clock cycles. Thus, a circuit tracking clock cycles can generate a notification to adjust a

circuit element or replace a circuit element with a corresponding spare circuit element preemptively, that is, before actual failure occurs.

FIG. 1 is a schematic block diagram of an integrated circuit according to a first embodiment of the present invention. In FIG. 1, an integrated circuit chip **100** includes a system clock generator **105**, a clock cycle counter **110**, a redundant clock cycle counter **110A**, a repair processor **115**, an optional fuse bank **120**, an original circuit **125** and a multiple of redundant circuits **125A** through **125N**, each redundant circuit capable of performing the same function as the original circuit. There may be only one redundant circuit. Additionally, integrated circuit **100** may include an on-chip count memory **130** for storing the cumulated number of cycles counted by clock cycle counter **110**. Alternatively, the count memory **130** may be implemented off-chip.

System clock generator (which may be a PLL circuit) generates a clock signal CLK supplied to original circuit **125** and a multiple of redundant circuits **125A** through **125N** and to clock cycle counter **110**. Clock cycle counter **110** keeps a running tally of the number of clock cycles that have occurred since the last power up after the last clock cycle counter RESET signal. A RESET signal is generated by repair processor **115** in response to a COUNTA signal sent from the clock cycle counter **110** and received by repair processor **115** that triggered a repair event. Repair processor **115** has the capability of performing all the tasks and generating all the signals required to affect a circuit repair. The current clock cycle count COUNTB, is stored in counter memory **130**. Since COUNTB should be resumed at power up, counter memory **130** should be a non-volatile

type memory such as non-volatile random access memory (NVRAM), which will save the value of COUNTB when the chip is powered down. Clock cycle counter **110** has the capability of restoring its count prior to a power down at a subsequent power up and continue counting clock cycle count from the restored count.

5 The first time repair processor receives a COUNTA triggering a replacement, original circuit **125** is replaced by redundant circuit **125A**. RESET signal is then generated causing cycle clock counter **110** to reset its count to zero clock cycles. The next time COUNTA reaches a value that triggers a replacement, redundant circuit **125A** is replaced by a subsequent redundant circuit in the set of redundant circuits **125A**
10 through **125N**. COUNTA and COUNT B may be the same signal, or different signals as discussed *infra*. Repair processor **115** may affect replacement directly or by electrically blowing fuses in fuse bank **120**, the pattern created by the states of the fuses directing inputs and outputs of the replaced circuit and the replacement circuit as required. However, any method of affecting repair may be used, including methods requiring the
15 off chip storage of the current repair status of integrated circuit **100**, so it can be restored at power up.

It should be noted, that clock cycle counter **110** may be repairable using the present invention. To this end, repair processor **115** can automatically insert redundant clock cycle counter **110A** between system clock generator **105**, memory counter **130** and
20 the repair processor itself in place of clock cycle counter **110** when a predetermined number of clock cycles are reached. This pre-determined number of clock cycles should

be significantly less than the COUNTA signal value. More than one redundant clock cycle counter may be provided and this process may be repeated as many times as there are redundant repair processors

FIG. 2 is a schematic block diagram of an integrated circuit according to a second embodiment of the present invention. In FIG. 2, integrated circuit 135 is similar to integrated circuit 100 of FIG. 1, except original circuit 125 and redundant circuits 125A through 125N of FIG. 1 are replaced with a field programmable gate array (FPGA) 140. A portion 145 of FPGA 140 is reserved for use as replacement gates to form a replacement circuit for a function performed by FPGA 140.

10 In the simplest approach, COUNTA and COUNTB are conveyed by buses between clock cycle generator 110 and repair processor 115 and between clock cycle counter 110 and counter memory 130 that are as wide as an internal counter within the clock cycle counter. However, a simple calculation shows that this approach requires a large number of wires, especially when multiple repair processors are distributed around
15 the integrated circuit. For example, given a 10GHz clock frequency and 10 years of power on operation requires a counter capable of counting $3.16E18$ clock cycles. The base 2 log of $3.16E18$ is 62, so a 62-bit counter is required as well as a 62-bit bus. Reducing the operating frequency to 1.25GHz only reduces the counter to 58-bits. A way of reducing the bus width and the associated circuit complexity is to employ most
20 significant bit (MSB) sampling in the repair processor. This approach is illustrated in FIGs. 3 and 4 and described *infra*.

FIG. 3 is a diagram illustrating a first circuit implementation of the clock cycle counter, repair processor and system clock generator components disclosed in the present invention. In FIG. 3, a clock cycle counter **110A** includes an $N+1$ bit register **150**, which holds the current value of COUNTB. Register **150** is sized to hold the maximum number of clock cycles to be counted. A repair processor **115A** includes an $M+1$ bit register **155**, which holds the current value of COUNTA. The last M -bits in register **150** are connected to corresponding bit positions in register **155**. M can be much smaller than N since repair processor **115A** does not need to know the exact clock cycle count but only what fraction of the maximum value of COUNTB has been reached. For example, if $M=3$ and the bits in register **155** are 0 0 0 1, then $1/16$ of the maximum number of clock cycles has been reached. When the bits in register **155** are 1 0 0 0 then $1/2$ of the maximum number of clock cycles has been reached. Repair processor **115A** can either be designed to react to any single bit of the M -bits of register **155** toggling, or to a pattern of all M -bits. Thus, only an M -bit wide bus is required. The particular set of M -bits selected from register **150** need not include the highest bits.

FIG. 4 is a diagram illustrating a second circuit implementation of the clock cycle counter, repair processor and system clock generator disclosed in the present invention. In FIG. 4, a clock cycle counter **110B** is similar to clock cycle counter **110A** of FIG. 3 except for the addition of a serialization circuit **160**, which takes the M -bits and generates a coded digital signal (COUNTA) that can be distributed by a single wire. Also, a repair

processor **115B** is similar to repair processor **115A** of FIG. 3, except for register **155A** being a shift register.

The approach to serialization of COUNTA can be expanded to serialize COUNTB in order to avoid the need for a multi-wire bus between clock cycle counter **110** and
5 counter memory **130**, particularly in the case when the counter memory is off-chip.

FIG. 5 is a diagram illustrating a third circuit implementation of the present invention, excluding the circuits selected for redundancy coverage and their redundant counterparts. In FIG. 5, a counter **110C** is similar to counter **110B** of FIG. 4 except a serialization circuit **160** converts the entire contents of register **150** into a coded digital
10 signal (COUNTB) that is connected to count memory **130**. Count memory **130** can be adapted to generate an overflow signal OVERFLOW to a repair processor **115C** in order to initiate a repair event.

Instead of using OVERFLOW to trigger a repair event, the M-bit COUNTA bus and attendant registers of FIG. 3 or serialized COUNTA bus and attendant registers of
15 FIG. 4 may also be used.

FIG. 6 is a schematic block diagram of an integrated circuit according to a third embodiment of the present invention. In FIG. 6, an integrated circuit chip **170** includes a system clock generator **175**, a clock cycle counter **180**, a redundant clock cycle counter **180A**, a multiple repair processors **185** and corresponding repairable circuits **190**, each
20 repairable circuit including an original circuit and one or more replacement circuits.

Additionally, integrated circuit **170** may include an on-chip count memory **195** for storing

the cumulated number of clocks counted by clock cycle counter **180**, or an off-chip memory may be use for this purpose. In the third embodiment of the present invention, a single clock cycle counter **180** serves multiple repair processors **185**. However, since the number of clock cycles required to trigger a replacement event can vary among repair
5 processors **185**, there is no RESET signal and a means for each repair processor **185** to determine when to trigger a repair event must be included within each repair processor.

FIG. 7 shows a fourth circuit implementation of the present invention, wherein multiple repair processors are triggered by different clock cycle counts and multiple times to effect multiple repairs. In FIG. 7, repair processor **200** includes a register **205** for
10 receiving an M-bit COUNTA signal as described *supra*. Repair processor **200** is also provided with a memory **210** which may be an FPGA or a fuse bank that stores sets of bits corresponding to one or more clock cycle counts on which a repair event should occur. A comparator **215** compares the contents of register **205** with all the sets of data bits stored in memory **210** and triggers the appropriate control signals to replacement
15 circuits **220**.

FIG. 8 is a schematic diagram of a first exemplary circuit utilizing the present invention. In FIG. 8, a redundant latch circuit **225** includes a sending latch **230** connected to a receiving latch **235** through combinatorial logic **240**, a redundant latch **245**, a clock cycle counter and repair processor **250** and multiple tristate buffers **255A**, **255B**, **255C**,
20 **255D** and **255E**. Clock cycle counter and repair processor **250** may include one or more redundant clock cycle counters. Tristate buffer is **255A** is inserted in the DATA path

between DATA IN and sending latch **230** and tristate buffer **255C** is inserted in the CLK path between CLK IN and sending latch **230**. Tristate buffer **255B** is inserted in the DATA path between DATA IN and redundant latch **245** and tristate buffer **255D** is inserted in the CLK path between CLK IN and redundant latch **245**. Tristate buffer **255E** is inserted in the data path between redundant latch **255E** and combinational logic **240**.

Depending on the number of elapsed clock cycles, clock cycle counter and repair processor **250** generates a CONTROL signal that either turns on tristate buffers **255A** and **255C** in order to pass DATA and CLK signals respectively to sending latch **230** and turns off tristate buffers **255B**, **255D** and **255E** or turns on tristate buffers **255B** and **255D** in order to pass DATA and CLK signals respectively to redundant latch **245** and connect redundant latch **245** to combinational logic **240** and turns off tristate buffers **255A** and **255C**. Tristate buffers **255A**, **255B**, **255C**, **255D** and **255E** may be replaced by 2:1 multiplexers.

FIG. 9 is a schematic diagram of a second exemplary circuit utilizing the present invention. In FIG. 9, an integrated circuit **255** includes a first PLL circuit **260A** and a second PLL circuit **260B**, each designed to generate clocks of different frequencies, a central clock tree driver **265**, a feedback buffer **270** designed to emulate the silicon and wire delay through a complete path in the tree, and four of sector buffer sets **275** used to drive the system clock through more local areas of the chip. Integrated circuit **255** further includes a clock cycle counter **280**, a repair processor **285**, four de-multiplexers **290** and four multiplexers **295** in order to implement sector buffer replacement. Clock cycle

counter **280** may include redundant clock cycle counters. There is one de-multiplexer **290** and one multiplexer **295** associated with each sector buffer set **275**. Each multiplexer **295** feeds a fan out to drive multiple local clock regenerators (not shown).

PLL circuits **260A** and **260B** are selectable to drive clock tree driver **265**.

- 5 Feedback circuit **270** allows the PLL circuits to matches the RC and silicon delay of the clock tree. Clock tree driver **265** provides a CLK signal to each de-multiplexer **290** and to clock cycle counter **280**. Clock cycle counter **280** supplies a COUNTA signal to repair processor **285**, which in turn provides SELECT signals to de-multiplexers **290** and multiplexers **295**. The SELECT signal “switches” out an “old” sector buffer and switches
- 10 in a “new” sector buffer. Clock cycle counter **280** and repair processor **285** may be implemented by any of the methods described *supra*.

- FIG. 10 is a flowchart illustrating a method of designing an integrated circuit according to the present invention. In step **300**, a high level design (HLD) of the integrated circuit is completed. In step **305**, design synthesis is performed in order to
- 15 generate a netlist **310** of the HLD from a library **315** of circuit elements. In step **320** simulation of the netlist design is performed. As part of the simulation, a switching report **325** is generated. Switching report **325** lists the total number of state toggles (input and /or output signal level changes) each circuit element made during the simulation.

- In step **330**, switching report **325** is used to select potential circuit elements that
- 20 could potentially “wear out” based on the switching factor or transition density of each circuit element as reported in switching report **325**, a predetermined degradation rate per

transition, a power on time specification and an acceptable degradation specification.

The degradation rate may be a function of the voltage level switched by the circuit element and may be process technology dependent.

In step **335**, repairable circuit elements having the same function as the circuit
5 elements selected in step **330** but including AND/OR legs, are selected from design
library **315**. The repairable elements may have N sets of AND/OR legs in order that
multiple “repairs” can be performed. In step **340**, the automatic synthesis tool adds one
or more clock cycle counter and one or more repair processors, which are selected from
design library **315**. The automated synthesis tool adds structures that connect the clock
10 cycle counters, repair processors and repairable circuit elements in a method similar to the
method used to building clock tree structures.

Generally, the method described herein with respect to designing an integrated
circuit having a digital reliability monitor having autonomic repair and notification
capability is practiced with a general-purpose computer and the method may be coded as
15 a set of instructions on removable or hard media for use by the general-purpose computer.

FIG. 11 is a schematic block diagram of a general-purpose computer for practicing the
present invention. In FIG. 11, computer system **400** has at least one microprocessor or
central processing unit (CPU) **405**. CPU **405** is interconnected via a system bus **410** to a
random access memory (RAM) **415**, a read-only memory (ROM) **420**, an input/output
20 (I/O) adapter **425** for a connecting a removable data and/or program storage device **430**
and a mass data and/or program storage device **435**, a user interface adapter **440** for

connecting a keyboard **445** and a mouse **450**, a port adapter **455** for connecting a data port **460** and a display adapter **465** for connecting a display device **470**.

ROM **420** contains the basic operating system for computer system **400**. The operating system may alternatively reside in RAM **415** or elsewhere as is known in the art. Examples of removable data and/or program storage device **430** include magnetic media such as floppy drives and tape drives and optical media such as CD ROM drives. Examples of mass data and/or program storage device **435** include hard disk drives and non-volatile memory such as flash memory. In addition to keyboard **445** and mouse **450**, other user input devices such as trackballs, writing tablets, pressure pads, microphones, light pens and position-sensing screen displays may be connected to user interface **440**. Examples of display devices include cathode-ray tubes (CRT) and liquid crystal displays (LCD).

A computer program with an appropriate application interface may be created by one skilled in the art and stored on the system or a data and/or program storage device to simplify the practicing of this invention. In operation, information for the computer program created to run the present invention is loaded on the appropriate removable data and/or program storage device **430**, fed through data port **460** or typed in using keyboard **445**.

Thus, the present invention provides a method for mitigating the probability of early failures due to increased operating frequency.

The description of the embodiments of the present invention is given above for the understanding of the present invention. It is understood that the invention is not limited to the particular embodiments described herein, but is capable of various modifications, rearrangements and substitutions as will now become apparent to those skilled in the art without departing from the scope of the invention. For example, after a given number of clock cycles a voltage regulator could be replaced with another voltage regulator of a different output voltage than the replaced voltage regulator, or the original voltage regulator can be adjusted to output a different voltage level than before in order to compensation for wear-out of circuits supplied by the voltage regulator. Further, the signal being counted need not be a clock signal but any signal switching between two (or more) states. The system may have inherent features of being total autonomic, or smart-autonomic. As various units as described above are replaced, an overall autonomic counter may be employed to keep track of the "health of the system," providing a weighted output that will elicit additional smart-autonomic controls. For example, if a voltage regulator is operating on it's last replacement module, the smart-autonomic controller may reduce the input voltage to the regulator thus placing it on a longer, or indefinite lifetime curve. The smart-autonomic controller may also send console messages, or log this event for a field repair to occur. The smart-autonomic controller may also, for example, replace a last failing unit (e.g. a system clock) with one that is optimized to operate at a reduced frequency, and is known as in the case of the voltage regulator to have an infinite lifetime curve. Such interventions are easily integrated with

technology alterations, in the case of the clock example by having an infinite lifetime clock designed at a gate length that is known reliable. In this case the unit would suffer frequency degradation, but as in the case of the voltage regulator, a console message or log can alert field service to replace the entire unit . Therefore, it is intended that the

5 following claims cover all such modifications and changes as fall within the true spirit and scope of the invention.